



Deposited via The University of York.

White Rose Research Online URL for this paper:

<https://eprints.whiterose.ac.uk/id/eprint/158687/>

Version: Accepted Version

Article:

Soares, Bruna, Abranches, Dinis O, Sintra, Tania E et al. (2020) Glycerol ethers as hydrotropes and their use to enhance the solubility of phenolic acids in water. *ACS Sustainable Chemistry & Engineering*. pp. 5742-5749. ISSN: 2168-0485

<https://doi.org/10.1021/acssuschemeng.0c01032>

Reuse

Items deposited in White Rose Research Online are protected by copyright, with all rights reserved unless indicated otherwise. They may be downloaded and/or printed for private study, or other acts as permitted by national copyright laws. The publisher or other rights holders may allow further reproduction and re-use of the full text version. This is indicated by the licence information on the White Rose Research Online record for the item.

Takedown

If you consider content in White Rose Research Online to be in breach of UK law, please notify us by emailing eprints@whiterose.ac.uk including the URL of the record and the reason for the withdrawal request.

Glycerol Ethers as Hydrotropes and their use to Enhance the Solubility of Phenolic Acids in Water

Bruna P. Soares¹, Dinis O. Abranches¹, Tânia E. Sintra¹, Alejandro Leal-Duaso², José I. García², Elísabet Pires², Seishi Shimizu³, Simão P. Pinho⁴ and João A. P. Coutinho^{1,*}

¹CICECO – Aveiro Institute of Materials, Department of Chemistry, University of Aveiro, 3810-193 Aveiro, Portugal

²Instituto de Síntesis Química y Catálisis Homogénea (ISQCH-CSIC) Facultad de Ciencias, C.S.I.C. - Universidad de Zaragoza, E-50009 Zaragoza, Spain

³York Structural Biology Laboratory, Department of Chemistry, University of York, Heslington, York YO10 5DD, United Kingdom

⁴Centro de Investigação de Montanha (CIMO), Instituto Politécnico de Bragança, Campus de Santa Apolónia, 5300-253 Bragança, Portugal.

* Corresponding Author E-mail: jcoutinho@ua.pt

Abstract

The use of glycerol ethers (with alkyl side chain ranging from one to six methyl groups) as hydrotropes to enhance the solubility of gallic and syringic acids in water was here studied. These compounds were selected due to their biological and industrial applications and for serving as model molecules for lignin solubilization. The results obtained were compared against traditional co-solvents, demonstrating the exceptional hydrotropic ability of glycerol ethers. Setschenow constants show that the hydrophobicities of both solute and hydrotrope play an important role in the solubility enhancement by hydrotropy, shedding light into its molecular mechanism.

The solubility curves of gallic acid and syringic acid in the aqueous glycerol ether solutions were fitted using a recently proposed statistical thermodynamics-based model. This allowed the estimation of solute recovery from hydrotropic solution by using water as antisolvent. Unlike what is usually claimed it is here shown that in some conditions it is impossible to recover the solute by simply adding water. This analysis paves the way for a rational design and selection of hydrotropes, in which both solubility enhancement and solute recovery are critical parameters to be taken into account.

Keywords: Green Chemistry, Hydrotropy, Phenolic Acids, Setschenow, Kirkwood-Buff, Cooperativity

Introduction

The concept of sustainable chemistry acquired great importance in the design of chemicals and processes less aggressive to the environment. Aiming at designing more sustainable extraction processes, the combination of alternative solvents from renewable and biological sources is an important cornerstone of Green Chemistry^{1,2}, combined preferentially with water, the greener universal solvent³⁻⁵. However, the low solubility in water of many organic compounds, some of which presenting relevant bioactivity, is one of the main shortcomings regarding the use of water to extract valuable compounds⁶. Increasing the solubility of poorly soluble substances in aqueous media, typically achievable by the addition of a co-solvent, plays an important role in the purification of bioactive compounds as well as in their formulation and bioavailability studies^{7,8}.

Hydrotropes are a class of water-soluble compounds with an amphiphilic structure that are able to increase the solubility of hydrophobic substances in water⁹. Hydrotropy has been applied in several scientific fields, such as lignin and cellulose dissolution and fractionation, with great success¹⁰⁻¹⁵. Hydrotropes can extend the applicability of water as a solvent to water-insoluble compounds, thus being highly relevant to Green Chemistry. However, since proposed by Neuberg¹⁶ in 1916, most compounds studied as hydrotropes are petrochemical-based, such as sodium benzene sulfonate (SBS), sodium toluene sulfonate (STS) or sodium xylene sulfonate (SXS). Non-ionic alkyl-hydrotropes such as ethylene glycol ethers and propylene glycol ethers have also been proposed^{9,17,18}. Recently, glycerol ethers have been shown to behave as hydrotropes, making them a promising bio-based alternative for the commonly petrochemical-based hydrotropes¹⁹, while possessing lower vapor pressures and higher boiling points than their glycol ethers counterparts²⁰.

Glycerol ethers are amphiphilic compounds that possess a central hydrophilic glycerol backbone, conferring them a certain degree of polarity, and apolar alkyl side-chains¹⁹⁻²¹. Besides glycerol being abundantly available (as a by-product of biodiesel production, for example²²), glycerol ethers are synthesized from it via a green pathway²³. Moreover, glycerol ethers may be viewed as *designer molecules*, since it is possible to tune their physicochemical properties by changing the number and size of their alkyl groups^{19,21,24-26}. The name of these compounds is usually abbreviated as [x.y.z], where x, y and z, as shown in Figure 1, represent the number of carbon atoms of the alkyl chains linked to the oxygens in the three different positions of the

glycerol backbone. A value of zero in any of these variables means that there is a proton linked to the oxygen instead of an alkyl chain, i.e. there is a hydroxyl group in that position.

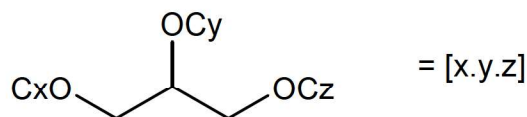


Figure 1. Nomenclature for the alkyl glycerol ethers studied in this work.

So far only a few works have been reported regarding the use of monoglycerol ethers as hydrotropes. Moity *et al.*²⁷ prepared three pentyl and three aryl 1-O-monoglyceryl ethers via esterification from glycerol, all presenting low volatility (vapor pressure below 0.01 kPa), and investigated their potential as hydrotropes. The results obtained show great solubility enhancement of a hydrophobic dye (Disperse Red 13), especially when using aryl monoglycerol ethers. Lebeuf *et al.*²⁸ have also studied the hydrotropic potential of mono, di and tri-alkyl glycerol ethers for a hydrophobic dye (Disperse Red 13). Some of the compounds studied, such as [2.1.1], [3.1.1], [4.1.1] and [2.2.2], have a solubility limit, not being fully miscible with water, and are also the most volatile. Among the hydrotropes studied, [5.0.0] presents the greater solubilization power at low concentrations (up to 30 wt.%) and possesses the highest boiling point (262 °C), making it one of the best candidates to be used as an hydrotrope in that case.

The present work investigates the effect of the alkyl side chain of glycerol ethers on the solubility enhancement of two phenolic acids, the poorly water-soluble gallic and syringic acids. They were selected as model compounds for this study due to their relevant bioactivities such as strong antioxidant properties^{29,30}, their presence in a wide variety of natural organic matrices and industrial applications^{30,31}, and their different levels of polarity, with syringic acid being more hydrophobic than gallic acid (suggested by their different octanol/water partition coefficients³²). Moreover, gallic and syringic acids are monomers of lignin and excellent model molecules for its solubility in hydrotropic systems, an active area of research^{11–13,33}. The experimental data obtained was used to better understand the mechanism of hydrotropy, through the calculation of Setschenow constants³⁴. Additionally, a recently proposed thermodynamics model of cooperative hydrotropy, developed by Shimizu and Matubayasi³⁵, was used to fit the solubility data, enabling an analysis for the estimation of the recovery ease of the solutes from the hydrotropic systems by using water as anti-solvent.

Experimental Section

Chemicals

The chemicals used in this work are displayed in Table 1, along with their source and mass purity. Water was double distilled, passed across a reverse osmosis system, and further treated with a Milli-Q plus 185 water purification apparatus. The alcohols were dried and distilled over calcium hydride previous to being used.

Table 1. List of substances used in this work along with their CAS number, source and purity.

Substance	CAS Number	Source	Purity (wt%)
Glycidol	556-52-5	Sigma-Aldrich	96
Epichlorohydrin	106-89-8	Sigma-Aldrich	99
Methanol	67-56-1	Scharlab	>99
Ethanol	64-17-5	Scharlab	>99
Sodium Hydroxide	1310-73-2	Scharlab	98
Hydrochloric Acid (37%)	7647-01-0	Fisher	
Propan-1-ol	71-23-8	Alfa Aesar	99.5
Butan-1-ol	71-36-3	Alfa Aesar	>99
Pentan-1-ol	71-41-0	Alfa Aesar	>99
Hexan-1-ol	111-27-3	Alfa Aesar	>99
Calcium Hydride	7789-78-8	Acros Organics	>93.0
Gallic Acid	149-91-7	Merck	>99.5
Syringic Acid	530-57-4	Acros Organics	>98.0
Glycerol	56-81-5	Fisher Chemical	>99.8
[1.0.0]	623-39-2	This work	>98 ^{b)}
[2.0.0]	1874-62-0	This work	>99 ^{b)}
[3.0.0]	61940-71-4	This work	>99 ^{b)}
[4.0.0]	624-52-2	This work	>99 ^{b)}
[5.0.0]	22636-32-4	This work	>99 ^{b)}
[6.0.0]	a)	This work	>99 ^{b)}
[1.0.1]	623-69-8	This work	>99 ^{b)}
[2.0.2]	4043-59-8	This work	>99 ^{b)}

a) Compound has no CAS number available. **b)** Estimated by NMR.

Synthesis of Glycerol Ethers

A scale up to 3 mol of the previously described glycerol ether synthesis was carried out^{24,25}. Thus, in order to synthesize glycerol monoethers, 45 mol of alcohol and sodium hydroxide (20 mol% with respect to glycidol) were placed into a round bottomed flask. The reaction mixture

1
2
3 was stirred and heated at 338 K, under argon, until total dissolution of the catalyst (NaOH).
4 Then, glycidol (3 mmol) was added dropwise. The reaction was monitored at different times
5 by extracting samples that were neutralized with 0.3 M HCl previous to injection in a Hewlett
6 Packard 7890 series II GC (Gas Chromatography), as described in section S1 of supporting
7 information. After the total consumption of glycidol, the reaction was quenched with 0.3 M
8 HCl and the salt formed (sodium chloride) was filtered off. Finally, the excess of the starting
9 alcohol was eliminated by reduced pressure distillation and glycerol monoethers were purified
10 by vacuum distillation.
11
12
13
14
15
16
17

18 To synthesize symmetric glycerol diethers, 45 mol of the corresponding alcohol and the
19 catalyst NaOH (4.2 mol), were placed into a round bottomed flask. The mixture was stirred
20 and heated at 338 K under argon until total dissolution of the base. Then, epichlorohydrin (3
21 mmol) was added dropwise. Reactions were monitored by GC until total consumption of
22 epichlorohydrin. Then, the reaction was also quenched with HCl 0.3 M and salts were filtered
23 off. Finally, the excess of the starting alcohol was distilled and recovered and the resulting
24 glycerol diether was purified by vacuum distillation.
25
26
27
28
29
30

31 Purity of the products was checked by proton and carbon nuclear magnetic resonance (¹H-
32 NMR, ¹³C-NMR), recording the spectra in a Bruker Avance 400 MHz device, and using
33 DMSO-*d*₆ (dimethyl sulfoxide-*d*₆) as solvent (with chemical shifts δ in ppm). All the obtained
34 spectra and the water content of each product (measured using Karl-Fischer titration) can be
35 found in section S1 of the supporting information.
36
37
38
39
40

41 Solubility Measurements

42

43 The solubility of the phenolic acids (gallic acid or syringic acid) was measured by the analytical
44 isothermal shake-flask method, previously described in detail⁶. The phenolic acid was added
45 in excess to each hydrotrope aqueous solution. For the aqueous systems the samples were
46 equilibrated in an air oven at (303.2 \pm 0.5) K under constant stirring (950 rpm) and an
47 equilibration time of 72 h, using an Eppendorf Thermomixer Comfort equipment. For the pure
48 glycerol ethers, which are more viscous than their aqueous solutions, the samples were placed
49 over plate stirrers inside a thermostatic water bath at (303.2 \pm 0.1) K for 72 h. The equilibration
50 conditions were previously optimized^{36,37}.
51
52
53
54
55
56
57

58 After equilibrium was reached (72 h), all samples were centrifuged at (303.2 \pm 0.5) K for 20
59 minutes using a Hettich Mikro 120 centrifuge operating at 4500 rpm, in order to separate the
60

1
2
3 excess undissolved solute from the liquid phase. After centrifugation, all samples were placed
4 in an air bath equipped with a Pt 100 probe and a PID controller at the temperature used in
5 equilibrium assays during 2 h. Then, the samples of the liquid phase were carefully collected
6 and diluted in ultra-pure water, and the amount of phenolic acid was quantified by
7 UV-spectroscopy using a SHIMADZU UV-1700, Pharma-Spec spectrometer at 262 and
8 267 nm for gallic and syringic acid, respectively. At least three individual samples were
9 quantified for each system.
10
11
12
13
14
15
16
17
18
19
20
21
22
23
24
25
26
27
28
29
30
31
32
33
34
35
36
37
38
39
40
41
42
43
44
45
46
47
48
49
50
51
52
53
54
55
56
57
58
59
60

Results and Discussion

Solubility Curves

The solubility of gallic acid and syringic acid (see Figure S9 for chemical structures) in aqueous solutions of glycerol ethers was measured in the entire concentration range, at 303.2 K, and is reported in section S2 of the supporting information (Tables S2-18). Since [6.0.0] forms a two-phase system with water¹⁹ at concentrations below 38 wt% its hydrotropic capability was studied only for gallic acid in the single-phase region.

The solubility data for gallic acid is shown in Figure 2, where S and S_0 represent the solubility (mol/L) of gallic acid in the aqueous solutions of the hydrotrope and in pure water, respectively. Choosing attainable maximum solubility as the metric of interest, the ability of the linear glycerol ethers to enhance the solubility of gallic acid increases in the following order: [6.0.0] < [5.0.0] < [4.0.0] < [3.0.0] < [2.0.0] < [1.0.0]. Moreover, [1.0.1] is better than [2.0.2] while glycerol shows the least solubility enhancement. This initial analysis suggests that the shorter the alkyl chain of the hydrotrope, the better the solubility enhancement. Note that the maximum solubility of gallic acid in aqueous [1.0.0] or [1.0.1] is about the same, with the plateau being reached at a lower concentration for the [1.0.1] curve.

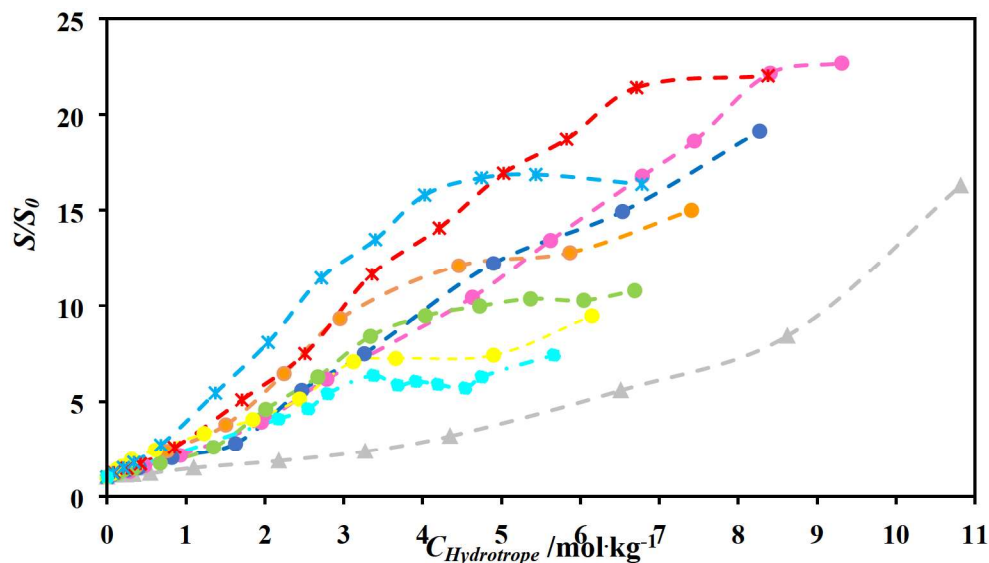


Figure 2. Effect of glycerol ether (hydrotrope) concentration on the solubility of gallic acid in aqueous solutions of [1.0.0] ●, [2.0.0] ●, [3.0.0] ●, [4.0.0] ●, [5.0.0] ●, [6.0.0] ●, [1.0.1] ■, [2.0.2] ■ and glycerol ▲, at 303.2 K. S/S_0 is the relative solubility (expressed in mol/L) of the solute and $C_{\text{Hydrotrope}}$ is the concentration of the hydrotrope in the solvent (solute-free basis). Dashed lines are visual guides.

The solubility data for syringic acid is depicted in Figure 3. Contrary to what is seen in Figure 2, most of the solubility curves depicted in Figure 3 pass through a maximum, with glycerol and [1.0.0] as the exceptions, suggesting an optimal concentration of hydrotrope. Again considering attainable maximum solubility as the metric of interest, the conclusions drawn from Figure 2 for gallic acid hold true for syringic acid as well. Hence, it appears that the smaller the hydrotrope the better the solubility enhancement. Interestingly, the increase in solubility of syringic acid is proportionally much more pronounced than that for gallic acid. For instance, it is possible to reach a 77-fold increase in the solubility of syringic acid using [1.0.1] while a 22-fold increase in solubility was achieved for gallic acid with the same hydrotrope.

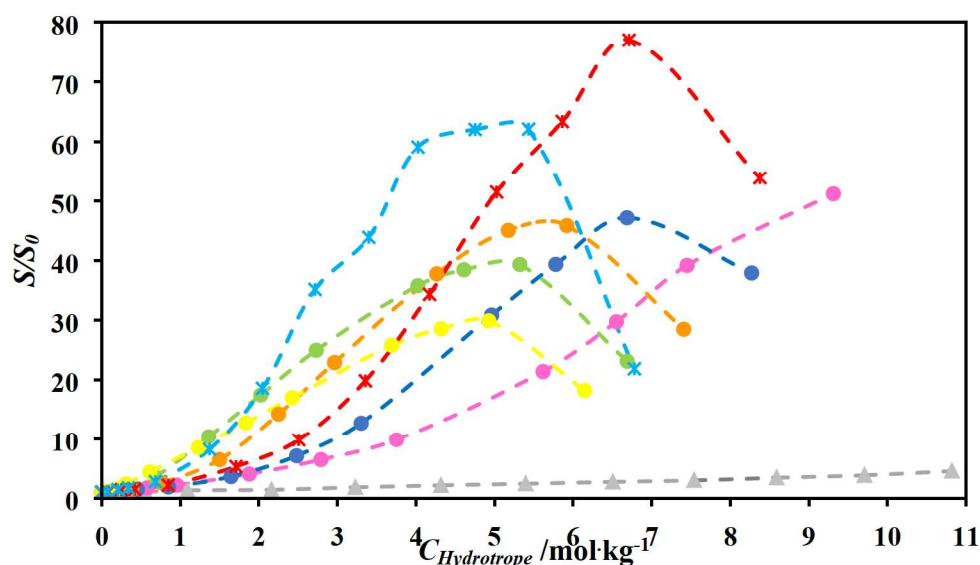


Figure 3. Effect of glycerol ether (hydrotrope) concentration on the solubility of syringic acid in aqueous solutions of [1.0.0] \bullet , [2.0.0] \bullet , [3.0.0] \bullet , [4.0.0] \bullet , [5.0.0] \bullet , [1.0.1] \times , [2.0.2] \times and glycerol \blacktriangle , at 303.2 K. S/S_0 is the relative solubility (expressed in mol/L) of the solute and $C_{\text{Hydrotrope}}$ is the concentration of the hydrotrope in the solvent (solute-free basis). Dashed lines are visual guides.

The solubility enhancement of gallic and syringic acids obtained using glycerol ethers as hydrotropes was compared against results using co-solvency with traditional solvents (Figure 4). As Figure 4 clearly demonstrates, glycerol ethers are much better solubilizing agents for gallic acid than traditional co-solvents such as methanol, acetonitrile and propan-2-ol. Even glycerol, the worst hydrotrope studied in this work, is better than traditional co-solvents. While methanol provides higher solubility values than glycerol in the solubilization of syringic acid, it is much inferior to [1.0.1] in most of the concentration range. Methanol is, indeed, commonly added to enhance the solubility of hydrophobic substances, but possesses high volatility and toxicity³⁸, contrary to the glycerol ethers studied in this work^{24,25,39,40}. It is interesting to note that the methanol solubility curve for gallic acid presents

a linear shape, in contrast with its sigmoidal shape for syringic acid, similar to what is expected in hydrotropy.

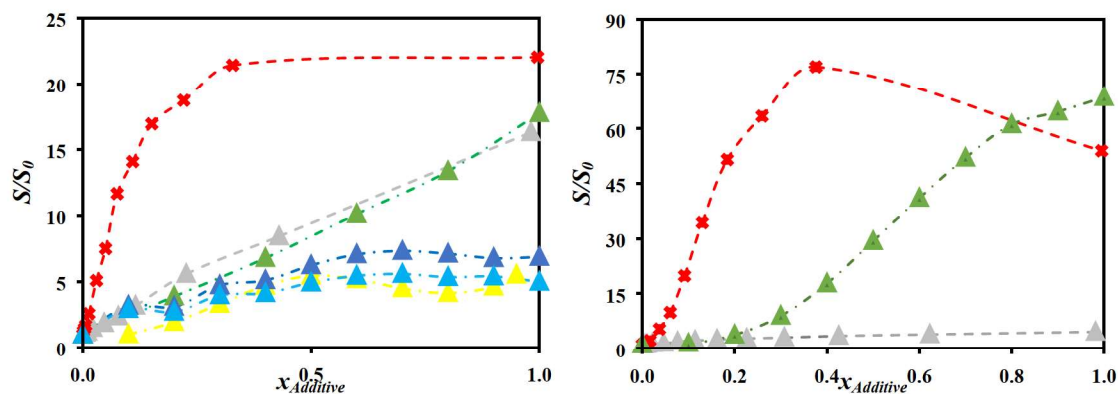


Figure 4. Solubility enhancement of gallic acid (left panel) and syringic acid (right panel) using the hydrotropes [1.0.1] ■, and [0.0.0] ▲ (this work) and the co-solvents methanol ▲^{41,42}, ethanol ▲⁴³ acetonitrile ▲⁴⁴ and propan-2-ol ▲⁴⁴. S/S_0 is the relative solubility (expressed in mol/L) of the solute and the x -axis represents the mole fraction of the additive (hydrotrope or co-solvent) in the solvent (solute-free basis). Dashed lines are visual guides.

Dilute Hydrotrope Region

The pronounced effect of glycerol ethers as hydrotrope agents, when compared to traditional organic solvents, is of great interest for extraction processes, especially in the replacement of traditional volatile organic compounds. However, apart from studying the entire concentration range of hydrotrope, the careful analysis of the dilute hydrotrope region is also important for the following reasons. Firstly, from an application-wise perspective, using smaller quantities of additives (hydrotropes) is economically preferable. Secondly, from a fundamental perspective the identification of the molecular mechanism of hydrotropy is easier in the dilute region where effects can be isolated (contribution from the hydrotrope self-association in the bulk phase can, for instance, be neglected). To study the dilute region the Setschenow constant was used.³⁴ Originally this was proposed as an empirical approach to describe the effect of a salt, or co-solvent on the solubility of a compound in aqueous solution, and has since been applied to describe the effect of hydrotropes on the aqueous solubility of solutes^{36,37}. It has been shown, using statistical thermodynamics, that this approach has a sound physical basis in the dilute region⁴⁵.

The Setschenow constant³⁴ quantifies the change in the solubility of a solute due to the presence of an hydrotrope, in the dilute region. It is herein defined as:

1
2
3
4
5
6
7
8
9
10
11
12
13
14

$$\ln(S_s) = K_H \cdot C_H \quad (1)$$

15
16
17
18
19
20
21
22

where S_s is the molar solubility of the solute, K_H is the Setschenow constant and C_H is the molarity of the hydrotrope. Equation 1 is valid from a hydrotrope molarity of zero up to a value where the variation of the natural logarithm of the solubility of the solute remains linear with the increase in the molarity of the hydrotrope (about 5 wt% for the hydrotropes studied in this work).

23
24
25
26
27
28
29
30
31
32

Besides being useful to quantify the hydrotropic power of a substance (albeit in the dilute region), Setschenow constants can also be linked to statistical thermodynamics. The Setschenow constants calculated as per Equation 1 are related to Kirkwood–Buff Integrals (KBI) through the following expression⁴⁵:

$$K_H = G_{S,H} - G_{S,W} \quad (2)$$

33
34
35
36
37
38
39
40
41
42
43
44
45
46
47
48
49
50
51
52
53
54
55
56
57
58
59
60

where $G_{S,H}$ is the KBI between solute and hydrotrope and $G_{S,W}$ is the KBI between solute and water. Equation 2 shows that the higher the Setschenow constant is, the higher the preference of the solute to interact with the hydrotrope instead of with water and, consequently, the higher the solubility enhancement of the solute.

The Setschenow constants were calculated (assuming density of the systems in the dilute region equal to that of water) for all solute-hydrotrope pairs reported in this work, except for [6.0.0] since solubility data in the dilute region is not available for this compound. These results are reported in Table 2. Interestingly, the values obtained are in contradiction with the initial qualitative analysis from Figures 2 and 3. That is, the hydrotropic power of glycerol ethers in the dilute region increases with the increase in size of the alkyl side chain, in line with previous studies²⁸: [0.0.0] < [1.0.0] < [2.0.0] < [3.0.0] < [4.0.0] < [5.0.0].

Table 2. Setschenow constants for gallic and syringic acids in the glycerol ether hydrotrope systems studied in this work, along with the hydrotrope molarity range considered in their calculation.

	Hydrotrope	Setschenow Constant	Molarity Range /M
Gallic acid	[0.0.0]	0.149	0-0.3
	[1.0.0]	0.802	0-0.5
	[2.0.0]	0.976	0-0.3
	[3.0.0]	1.273	0-0.2
	[4.0.0]	1.528	0-0.2
	[5.0.0]	2.054	0-0.2
	[1.0.1]	1.171	0-0.3
	[2.0.2]	1.560	0-0.2
Syringic acid	[0.0.0]	0.129	0-0.6
	[1.0.0]	0.988	0-0.3
	[2.0.0]	0.759	0-0.3
	[3.0.0]	1.148	0-0.2
	[4.0.0]	1.604	0-0.2
	[5.0.0]	2.443	0-0.2
	[1.0.1]	1.401	0-0.3
	[2.0.2]	1.667	0-0.2

The results reported in Table 2 are in agreement with a previous study by Bauduin and co-workers¹⁷ that suggested the apolar volume of an hydrotrope to be directly connected with its capability to enhance the solubility of a solute. In fact, the progressive increase, through the addition of methyl groups, in apolar volume of the glycerol ethers seems to positively correlate with the Setschenow constants obtained, shedding light into the molecular mechanisms of hydrotropy.

Considering Equation 2, which has shown that Setschenow constants increase if the KBI of the solute-hydrotrope pair increases or the KBI of the solute-water pair decreases, it makes sense that apolarity or hydrophobicity plays a role in hydrotropy. An increase in the hydrophobicity of the solute should lead to a decrease of its interaction with water, leading to a decrease of the solute-water KBI and a consequent increase in the Setschenow constant. This is exactly what is seen in this work: for the same hydrotrope, the Setschenow constant obtained for systems containing syringic acid are higher than that of gallic acid (syringic acid has a higher octanol/water partition coefficient than gallic acid, suggesting it is more hydrophobic than gallic acid³²). On the other hand, increasing the hydrophobicity of the hydrotrope weakens its interaction with water, promoting interaction with the hydrophobic solute, leading to an

1
2
3 increase in the solute-hydrotrope KBI, increasing the Setschenow constant, in accordance to
4 what is reported in Table 2.
5

6
7 It is not yet clear why there is an inversion on the behavior of the hydrotropic power of glycerol
8 ethers above a certain concentration range, with more hydrophobic hydrotropes being better at
9 low concentrations and more hydrophilic hydrotropes being better at higher concentrations.
10 The Setschenow analysis above reveals that the size of the alkyl chain length appears to be the
11 dominating factor at low concentrations. However, it is expectable that increasing hydrotrope
12 concentration will also increase the activity coefficient of water, as supported by the
13 immiscibility observed for [6.0.0]. That is, increasing the alkyl chain length of the hydrotrope
14 increases its hydrophobicity, leading to a less favorable interaction to water for high hydrotrope
15 concentration. Thus, above a certain concentration of these hydrotropes, the nefarious effect of
16 being too hydrophobic prevails over favorable solute-hydrotrope interactions, leading to a
17 drastic negative impact in the hydrotropic behavior.
18
19
20
21
22
23
24
25
26

27 Modelling

28
29 The solubility data obtained in this work was fitted using a statistical thermodynamics-based
30 model developed by Shimizu and Matubayasi³⁵. This model based on the cooperativity concept
31 was developed not only to describe the usual sigmoidal solubility curves found in hydrotropy
32 but also to give insight into the interactions between solute and hydrotrope molecules. The
33 model can be expressed as:
34
35
36
37

$$38 \ln \left[\frac{1 - \frac{x_S}{x_{S,0}}}{\frac{x_S}{x_{S,0}} - \left(\frac{x_S}{x_{S,0}} \right)_{max}} \right] = m \cdot \ln(x_H) + b \quad (3)$$

39
40
41
42
43

44 where x_S is the solute saturation mole fraction (solubility) in the hydrotropic system, $x_{S,0}$ is the
45 solute saturation mole fraction in water and x_H is the mole fraction of the hydrotrope. Note that
46 x_H is not the mole fraction of the hydrotrope in a solute-free basis but its mole fraction in the
47 ternary water-hydrotrope-solute system; interconversion between them is done assuming the
48 density of the mixture equal to that of water. From the definition of x_S and $x_{S,0}$ it becomes clear
49 that the term $x_S/x_{S,0}$ represents the relative solubility in mole fraction basis. As such,
50 $(x_S/x_{S,0})_{max}$ (henceforth *max*) is the maximum of the relative solubility caused by a given
51 hydrotrope, i.e. the value of the plateau in the sigmoidal solubility curve. Finally, m and b are
52 parameters that give insight into the molecular interactions between solute and hydrotrope.
53
54
55
56
57
58
59
60

More specifically, m represents the number of hydrotrope molecules in the vicinity of the solute³⁵.

Due to the difficulty of identifying a clear solubility plateau in the many of the systems studied in this work, the parameter max was treated as an adjustable parameter of the model. Note that m and b are not adjustable parameters of the model, since they are directly calculated from the experimental data and the max parameter. The modelling algorithm used goes as follow. A value is arbitrarily chosen for variable max . Then, the m and b are parameters are extracted from the experimental data as the slope and intercept of the linearized curve defined as:

$$Y = \ln \left[\frac{1 - \frac{x_S}{x_{S,0}}}{\frac{x_S}{x_{S,0}} - \left(\frac{x_S}{x_{S,0}} \right)_{max}} \right]; x = \ln(x_H) \quad (4)$$

Using the calculated m and b parameters, the experimental data is reproduced using the model and the quadratic error between predicted and experimental data is calculated. Variable max is then varied until the sum of the quadratic errors is minimized. This procedure for the application of the model is illustrated in Figure 5a) with Equation 4 and Figure 5b) with the actual fitting, both for the syringic acid-[3.0.0] solute-hydrotrope pair. Fitted curves for all systems herein studied are depicted in section S3 of the supporting information (Figures S10 and S11).

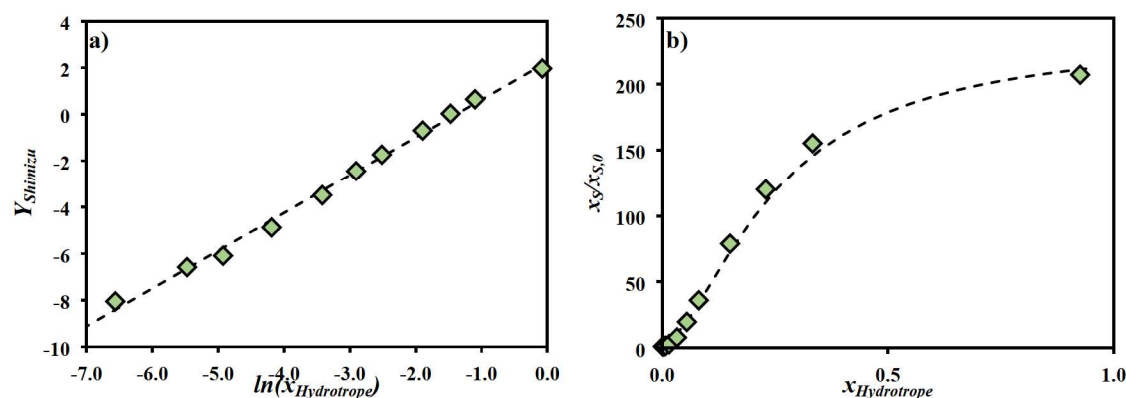


Figure 5. Linearized plot of the cooperative hydrotropy model based on Equation 4 (left panel, \blacklozenge experimental data, - - - least squares fit) and fitted experimental data (right panel, \blacklozenge experimental data, - - - cooperative hydrotropy model) for the water-[3.0.0]-syringic acid system. The x-axis represents the mole fraction of the hydrotrope in the ternary system (as opposed to its mole fraction in the solvent free of solute).

As Figures S10 and S11 show (see section S3 of the supporting information), the model reproduces the experimental data quite well. It is curious to note that the characteristic

1
2
3 sigmoidal shape of hydrotropic solubility curves is much more patent in the systems with
4 syringic acid than in the systems with gallic acid. Moreover, it is important to note that
5 expressing the composition of hydrotrope in the actual ternary system instead of its
6 composition in the solvent (solute-free basis) removes the maxima seen in the solubility curves
7 depicted in Figures 2 and 3. No clear pattern can be identified on the model parameters, which
8 are reported in Table S19 of the supporting information.
9
10
11
12

13
14 The cooperative model employed in this work (Equation 3) can be applicable not only to
15 cooperative (sigmoidal) solubility increases but also linear (non-cooperative cases), such as
16 those seen for gallic acid. In the latter case, m becomes close to 1, leading to a very large max
17 variable. Thus, the general applicability of the model is supported by its success in describing
18 both linear and sigmoidal solubility curves.
19
20
21
22

23 Solute Recovery

24 Besides quantifying their dissolution ability, it is fundamental to address the recovery of solute
25 from hydrotropic solutions. For most organic solvents, a simple evaporation suffices. However,
26 evaporating water from a hydrotropic solution would increase hydrotrope concentration which,
27 generally, would increase the solubility of the solute. Moreover, the hydrotropes are often non,
28 or poorly volatile. There is, however, a clever turnaround that allows for the easy recovery of
29 solute from an hydrotrope solution with similar energy cost when compared to traditional
30 solvents: the use of water as anti-solvent. As proposed in previous works^{18,46-48}, addition of
31 water to an hydrotropic solution may induce the precipitation of the solute due to the dilution
32 of the hydrotrope, providing an easy and straightforward approach to recover the solute in high
33 purity.
34
35
36
37
38
39
40
41
42
43

44 Whether this approach to solute recovery is feasible was here evaluated by calculating the
45 recoverable fraction of dissolved solute, using the solubility curves modelling reported in the
46 previous section. The calculation algorithm and detailed results are reported in section S4 of
47 the supporting information. Figure 6 illustrates the recovery curves (recovered solute fraction
48 versus water volume fraction added) obtained using the hydrotrope [1.0.1] for gallic acid and
49 syringic acid. Note that a negative solute fraction is possible, meaning that there is no
50 precipitation and the system is no longer saturated, thus, being able to dissolve more solute.
51
52
53
54
55
56
57
58
59
60

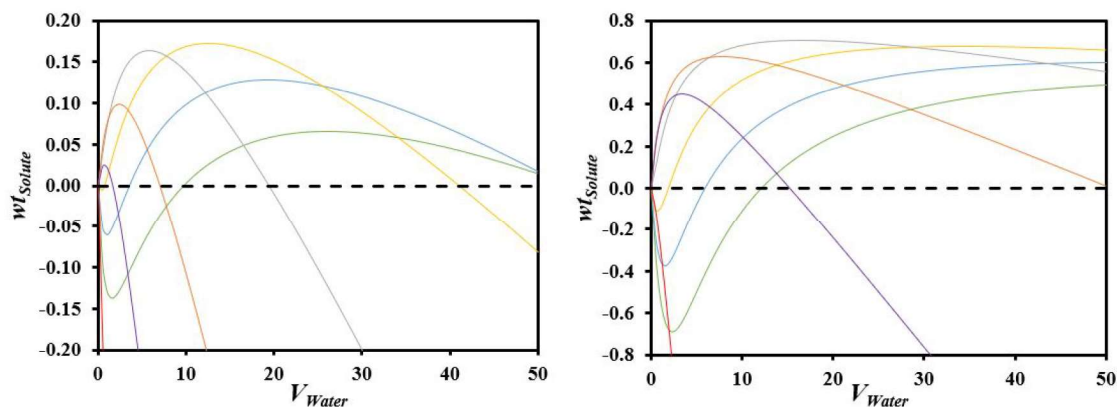


Figure 6. Estimated fraction of gallic acid (left panel) and syringic acid (right panel) recovered from hydrotrope solution (wt_{Solute}) by the addition of water (V_{Water} is the volumetric ratio between added water and initial system), with an initial hydrotrope mole fraction of 0.01 —, 0.05 —, 0.1 —, 0.2 —, 0.4 —, 0.6 — and 0.8 —. A negative value indicates that no precipitation happens, with the system being able to dissolve further solute.

Surprisingly, addition of water does not always lead to solute precipitation. Considering the examples depicted in Figure 6, both hydrotrope and its composition clearly play a role in determining the feasibility of recovering the solute by using water as anti-solvent. For instance, in this case (gallic acid-[1.0.1] system), the solute can only be recovered if the hydrotrope mole fraction is in the 0.05-0.4 range, with a maximum recovery of 17% achieved in the 0.2-0.4 hydrotrope mole fraction range. If the hydrotrope mole fraction is higher than 0.4, the solute may still be recoverable but only after the addition of a large quantity of water. Below a mole fraction of 0.05, solute recovery is unfeasible. These conclusions are similar for the syringic acid-[1.0.1] system. In this case, the solute can be recovered in a narrower mole fraction window, but up to 70% can be recovered.

Despite the increased volume of water when water is added to a hydrotropic system, the hydrotrope becomes less concentrated, which makes hydrotrope less effective. Whether any amount of solute precipitates from a hydrotrope solution after adding water is determined by the trade-off between these two factors. Thus, the recovery of solute is more favorable as the slope of the solute solubility curve increases, which corresponds to a bigger change in solubility due to a smaller change in hydrotrope concentration. It is also important to note that, since syringic acid is much less soluble in water than gallic acid, it is easier to recover it since the first factor (solute dissolution in the new water volume) loses importance. Moreover, the slope of the solubility curves tends to be higher in mid composition ranges of hydrotrope (sigmoidal shape), explaining the recovery windows positioned in mid hydrotrope mole fractions.

1
2
3 Figure S12 reveals that, in terms of gallic acid recovery, it is better to use a hydrotrope mole
4 fraction of 0.2-0.8 for the most hydrophilic hydrotropes ([1.0.0] and [2.0.0]), whilst a 0.05-0.2
5 window is better for the least hydrophilic ones. Interestingly, it is impossible (using the addition
6 of water) to recover gallic acid dissolved in aqueous [5.0.0] solutions. The same conclusions
7 hold true for syringic acid, as Figure S13 shows, albeit in narrower mole fraction windows,
8 similarly to what was concluded through the analysis of Figure 6. The biggest difference is the
9 fraction of solute recovered, which is much higher for syringic acid than for gallic acid, due to
10 the almost 10-fold difference between their solubility in pure water.
11
12
13
14
15
16
17

18 **Conclusions**

19
20 The solubility of gallic acid and syringic acid was measured in aqueous solutions of glycerol
21 ethers, a recently proposed new class of hydrotropes, demonstrating their excellent hydrotropic
22 ability. Their solubilization capacity is more prominent for the smaller, more hydrophilic
23 hydrotropes and is superior to traditional organic co-solvents.
24
25
26
27

28 The Setschenow constants for the hydrotropic systems shed light into the hydrotropy
29 mechanism of these systems. The results show that the hydrophobicity of the hydrotrope plays
30 a major role in hydrotropy, being dominant in the dilute region. Furthermore, the
31 hydrophobicity of the solute is also important, since its relative solubility enhancement is
32 directly linked to it.
33
34
35
36

37 The experimental data herein obtained was fitted using the cooperative hydrotropy model. It
38 provided appropriate fitting and allowed for the analysis of the feasibility of recovering solute
39 from hydrotropic solutions by the addition of water. It was herein shown that solute recovery
40 is not always possible. As such, the choice of hydrotrope and operating concentration for a
41 given application should consider not only the solubility enhancement provided by the
42 hydrotrope but also the ease of solute recovery from the system.
43
44
45
46
47
48

49 **Acknowledgments**

50
51 This work was developed within the scope of the projects CICECO-Aveiro Institute of
52 Materials, UIDB/50011/2020 & UIDP/50011/2020, and Associate Laboratory LSRE-LCM,
53 POCI-01-0145-FEDER-006984 (Ref. FCT UID/EQU/50020/2019), both financed by national
54 funds through the FCT/MEC and when appropriate co-financed by FEDER under the PT2020
55 Partnership Agreement. The NMR spectrometers are part of the National NMR Network
56
57
58
59
60

(PTNMR) and are partially supported by Infrastructure Project N° 022161 (co-financed by FEDER through COMPETE 2020, POCI and PORL and FCT through PIDDAC). Financial support from Ministerio de Ciencia, Innovación (project RTI2018-093431-B-I00) and the Gobierno de Aragón (Group E37_17R) co-funded by FEDER 2014-2020 “Construyendo Europa desde Aragón” is acknowledged. Alejandro Leal-Duaso thanks the MECED for a FPU grant (FPU14/04338). B.P.S. acknowledges FCT for her Ph.D. grant SFRH/BD/138439/2018.

Supporting Information

The Supporting Information is available free of charge at: [https://pubs.acs.org/doi/????/???.](https://pubs.acs.org/doi/????/???)

SI includes product characterization, solubility data, computational details, tables and figures. Table S1: water content of the glycerol ethers. Tables S2-S10: gallic acid solubility in aqueous glycerol ethers. Tables S11-S18: syringic acid solubility in aqueous glycerol ethers. Table S19: cooperative hydrotrophy model parameters. Figures S1-S8: ¹H-NMR and ¹³C-NMR of the synthesized glycerol ethers. Figure S9: chemical structures of gallic and syringic acids. Figures S10-S11: cooperative hydrotrophy model solubility curves. Figures S12-S13: solute recoverability from hydrotropic solutions.

References

- (1) Anastas, P. *Green Chemistry: Theory and Practice*; Oxford University Press: New York, United States, 2000.
- (2) DeVierno Kreuder, A.; House-Knight, T.; Whitford, J.; Ponnusamy, E.; Miller, P.; Jesse, N.; Rodenborn, R.; Sayag, S.; Gebel, M.; Aped, I.; et al. A Method for Assessing Greener Alternatives between Chemical Products Following the 12 Principles of Green Chemistry. *ACS Sustain. Chem. Eng.* **2017**, *5* (4), 2927–2935.
- (3) Byrne, F. P.; Jin, S.; Paggiola, G.; Petchey, T. H. M.; Clark, J. H.; Farmer, T. J.; Hunt, A. J.; Robert McElroy, C.; Sherwood, J. Tools and Techniques for Solvent Selection: Green Solvent Selection Guides. *Sustain. Chem. Process.* **2016**, *4* (1), 7.
- (4) Clarke, C. J.; Tu, W.-C.; Levers, O.; Bröhl, A.; Hallett, J. P. Green and Sustainable Solvents in Chemical Processes. *Chem. Rev.* **2018**, *118* (2), 747–800.
- (5) Erythropel, H. C.; Zimmerman, J. B.; de Winter, T. M.; Petitjean, L.; Melnikov, F.; Lam, C. H.; Lounsbury, A. W.; Mellor, K. E.; Janković, N. Z.; Tu, Q.; et al. The Green ChemisTREE: 20 Years after Taking Root with the 12 Principles. *Green Chem.* **2018**,

- 1
2
3
4 20 (9), 1929–1961.
- 5
6 (6) Mota, F. L.; Queimada, A. J.; Pinho, S. P.; Macedo, E. A. Aqueous Solubility of Some
7 Natural Phenolic Compounds. *Ind. Eng. Chem. Res.* **2008**, *47* (15), 5182–5189.
- 8
9
10 (7) Savjani, K. T.; Gajjar, A. K.; Savjani, J. K. Drug Solubility: Importance and
11 Enhancement Techniques. *ISRN Pharm.* **2012**, *2012*, 1–10.
- 12
13
14 (8) Veleva, V. R.; Cue, B. W.; Todorova, S. Benchmarking Green Chemistry Adoption by
15 the Global Pharmaceutical Supply Chain. *ACS Sustain. Chem. Eng.* **2018**, *6* (1), 2–14.
- 16
17
18 (9) Hodgdon, T. K.; Kaler, E. W. Hydrotropic Solutions. *Curr. Opin. Colloid Interface*
19 *Sci.* **2007**, *12* (3), 121–128.
- 20
21
22 (10) Chen, L.; Dou, J.; Ma, Q.; Li, N.; Wu, R.; Bian, H.; Yelle, D. J.; Vuorinen, T.; Fu, S.;
23 Pan, X.; et al. Rapid and near-Complete Dissolution of Wood Lignin at $\leq 80^\circ\text{C}$ by a
24 Recyclable Acid Hydrotrope. *Sci. Adv.* **2017**, *3* (9), e1701735.
- 25
26
27
28 (11) Cai, C.; Hirth, K.; Gleisner, R.; Lou, H.; Qiu, X.; Zhu, J. Y. Maleic Acid as a
29 Dicarboxylic Acid Hydrotrope for Sustainable Fractionation of Wood at Atmospheric
30 Pressure and $\leq 100^\circ\text{C}$: Mode and Utility of Lignin Esterification. *Green Chem.* **2020**.
- 31
32
33 (12) Soares, B.; Silvestre, A. J. D.; Rodrigues Pinto, P. C.; Freire, C. S. R.; Coutinho, J. A.
34 P. Hydrotrophy and Cosolvency in Lignin Solubilization with Deep Eutectic Solvents.
35 *ACS Sustain. Chem. Eng.* **2019**, acsuschemeng.9b02109.
- 36
37
38
39 (13) Soares, B.; Tavares, D. J. P.; Amaral, J. L.; Silvestre, A. J. D.; Freire, C. S. R.;
40 Coutinho, J. A. P. Enhanced Solubility of Lignin Monomeric Model Compounds and
41 Technical Lignins in Aqueous Solutions of Deep Eutectic Solvents. *ACS Sustain.*
42 *Chem. Eng.* **2017**, *5* (5), 4056–4065.
- 43
44
45
46 (14) Song, Y.; Chandra, R. P.; Zhang, X.; Tan, T.; Saddler, J. N. Comparing a Deep
47 Eutectic Solvent (DES) to a Hydrotrope for Their Ability to Enhance the Fractionation
48 and Enzymatic Hydrolysis of Willow and Corn Stover. *Sustain. Energy Fuels* **2019**, *3*
49 (5), 1329–1337.
- 50
51
52
53 (15) Gabov, K.; Fardim, P.; Gomes da Silva Júnior, F. Hydrotropic Fractionation of Birch
54 Wood into Cellulose and Lignin: A New Step Towards Green Biorefinery.
55 *BioResources* **2013**, *8* (3), 3518–3531.
- 56
57
58
59
60

- 1
2
3
4 (16) Neuberg, C. Hydrotropic Phenomena. *Biochem. Z* **1916**, 76 (1), 107–108.
- 5
6 (17) Bauduin, P.; Renoncourt, A.; Kopf, A.; Touraud, D.; Kunz, W. Unified Concept of
7 Solubilization in Water by Hydrotropes and Cosolvents. *Langmuir* **2005**, 21 (15),
8 6769–6775.
- 9
10
11 (18) *Liquid Detergents*; Lai, K.-Y., Ed.; CRC Press: Boca Raton, United States, 2005.
- 12
13
14 (19) Queste, S.; Bauduin, P.; Touraud, D.; Kunz, W.; Aubry, J.-M. Short Chain Glycerol 1-
15 Monoethers—a New Class of Green Solvo-Surfactants. *Green Chem.* **2006**, 8 (9),
16 822–830.
- 17
18
19 (20) Queste, S.; Michina, Y.; Dewilde, A.; Neueder, R.; Kunz, W.; Aubry, J.-M.
20 Thermophysical and Bionotox Properties of Solvo-Surfactants Based on Ethylene
21 Oxide, Propylene Oxide and Glycerol. *Green Chem.* **2007**, 9 (5), 491–499.
- 22
23
24 (21) García, J. I.; García-Marín, H.; Mayoral, J. A.; Pérez, P. Green Solvents from
25 Glycerol. Synthesis and Physico-Chemical Properties of Alkyl Glycerol Ethers. *Green*
26 *Chem.* **2010**, 12 (3), 426–434.
- 27
28
29 (22) Leoneti, A. B.; Aragão-Leoneti, V.; de Oliveira, S. V. W. B. Glycerol as a by-Product
30 of Biodiesel Production in Brazil: Alternatives for the Use of Unrefined Glycerol.
31 *Renew. Energy* **2012**, 45, 138–145.
- 32
33
34 (23) Sutter, M.; Silva, E. Da; Duguet, N.; Raoul, Y.; Métay, E.; Lemaire, M. Glycerol Ether
35 Synthesis: A Bench Test for Green Chemistry Concepts and Technologies. *Chem. Rev.*
36 **2015**, 115 (16), 8609–8651.
- 37
38
39 (24) Leal-Duaso, A.; Caballero, M.; Urriolabeitia, A.; Mayoral, J. A.; García, J. I.; Pires, E.
40 Synthesis of 3-Alkoxypropan-1,2-Diols from Glycidol: Experimental and Theoretical
41 Studies for the Optimization of the Synthesis of Glycerol Derived Solvents. *Green*
42 *Chem.* **2017**, 19 (17), 4176–4185.
- 43
44
45 (25) Leal-Duaso, A.; Pérez, P.; Mayoral, J. A.; Pires, E.; García, J. I. Glycerol as a Source
46 of Designer Solvents: Physicochemical Properties of Low Melting Mixtures
47 Containing Glycerol Ethers and Ammonium Salts. *Phys. Chem. Chem. Phys.* **2017**, 19
48 (41), 28302–28312.
- 49
50
51 (26) Leal-Duaso, A.; Pérez, P.; Mayoral, J. A.; García, J. I.; Pires, E. Glycerol-Derived
52 Solvents: Synthesis and Properties of Symmetric Glyceryl Diethers. *ACS Sustain.*
53
54
55
56
57
58
59
60

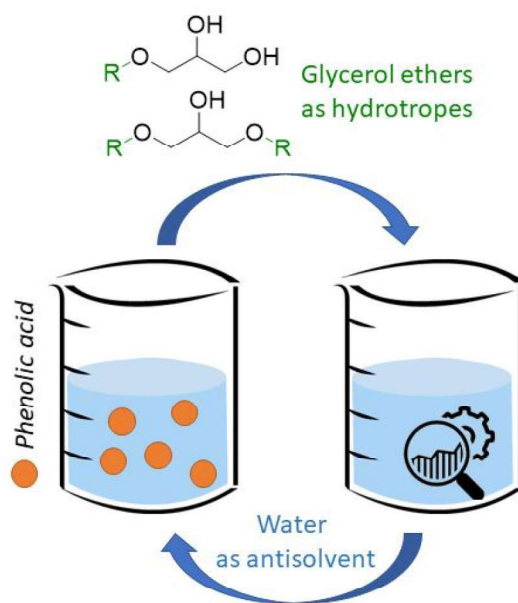
- 1
2
3
4
5
6
7
8
9
10
11
12
13
14
15
16
17
18
19
20
21
22
23
24
25
26
27
28
29
30
31
32
33
34
35
36
37
38
39
40
41
42
43
44
45
46
47
48
49
50
51
52
53
54
55
56
57
58
59
60
- Chem. Eng.* **2019**, 7 (15), 13004–13014.
- (27) Moity, L.; Shi, Y.; Molinier, V.; Dayoub, W.; Lemaire, M.; Aubry, J.-M. Hydrotropic Properties of Alkyl and Aryl Glycerol Monoethers. *J. Phys. Chem. B* **2013**, 117 (31), 9262–9272.
- (28) Lebeuf, R.; Illous, E.; Dussenne, C.; Molinier, V.; Silva, E. Da; Lemaire, M.; Aubry, J.-M. Solvo-Surfactant Properties of Dialkyl Glycerol Ethers: Application as Eco-Friendly Extractants of Plant Material through a Novel Hydrotropic Cloud Point Extraction (HCPE) Process. *ACS Sustain. Chem. Eng.* **2016**, 4 (9), 4815–4823.
- (29) Choubey, S.; Varughese, L. R.; Kumar, V.; Beniwal, V. Medicinal Importance of Gallic Acid and Its Ester Derivatives: A Patent Review. *Pharm. Pat. Anal.* **2015**, 4 (4), 305–315.
- (30) Srinivasulu, C.; Ramgopal, M.; Ramanjaneyulu, G.; Anuradha, C. M.; Suresh Kumar, C. Syringic Acid (SA) – A Review of Its Occurrence, Biosynthesis, Pharmacological and Industrial Importance. *Biomed. Pharmacother.* **2018**, 108, 547–557.
- (31) Badhani, B.; Sharma, N.; Kakkar, R. Gallic Acid: A Versatile Antioxidant with Promising Therapeutic and Industrial Applications. *RSC Adv.* **2015**, 5 (35), 27540–27557.
- (32) ChemSpider <http://www.chemspider.com/> (accessed Jun 15, 2019).
- (33) Alzagameem, A.; Khaldi-Hansen, B.; Büchner, D.; Larkins, M.; Kamm, B.; Witzleben, S.; Schulze, M. Lignocellulosic Biomass as Source for Lignin-Based Environmentally Benign Antioxidants. *Molecules* **2018**, 23 (10), 2664.
- (34) Setschenow, J. Über Die Konstitution Der Salzlösungen Auf Grund Ihres Verhaltens Zu Kohlensäure. *Zeitschrift für Phys. Chemie* **1889**, 4 (1), 117–125.
- (35) Shimizu, S.; Matubayasi, N. The Origin of Cooperative Solubilisation by Hydrotropes. *Phys. Chem. Chem. Phys.* **2016**, 18 (36), 25621–25628.
- (36) Sintra, T. E.; Shimizu, K.; Ventura, S. P. M.; Shimizu, S.; Canongia Lopes, J. N.; Coutinho, J. A. P. Enhanced Dissolution of Ibuprofen Using Ionic Liquids as Catanionic Hydrotropes. *Phys. Chem. Chem. Phys.* **2018**, 20 (3), 2094–2103.
- (37) Cláudio, A. F. M.; Neves, M. C.; Shimizu, K.; Canongia Lopes, J. N.; Freire, M. G.;

- 1
2
3 Coutinho, J. A. P. The Magic of Aqueous Solutions of Ionic Liquids: Ionic Liquids as
4 a Powerful Class of Catanionic Hydrotropes. *Green Chem.* **2015**, *17* (7), 3948–3963.
5
6
7
8 (38) Chemat; Abert Vian; Ravi; Khadhraoui; Hilali; Perino; Tixier. Review of Alternative
9 Solvents for Green Extraction of Food and Natural Products: Panorama, Principles,
10 Applications and Prospects. *Molecules* **2019**, *24* (16), 3007.
11
12
13 (39) Perales, E.; García, J. I.; Pires, E.; Aldea, L.; Lomba, L.; Giner, B. Ecotoxicity and
14 QSAR Studies of Glycerol Ethers in *Daphnia Magna*. *Chemosphere* **2017**, *183*, 277–
15 285.
16
17
18 (40) García, J. I.; Pires, E.; Aldea, L.; Lomba, L.; Perales, E.; Giner, B. Ecotoxicity Studies
19 of Glycerol Ethers in *Vibrio Fischeri*: Checking the Environmental Impact of
20 Glycerol-Derived Solvents. *Green Chem.* **2015**, *17* (8), 4326–4333.
21
22
23
24 (41) Noubigh, A.; Aydi, A.; Mgaidi, A.; Abderrabba, M. Measurement and Correlation of
25 the Solubility of Gallic Acid in Methanol plus Water Systems from (293.15 to 318.15)
26 K. *J. Mol. Liq.* **2013**, *187*, 226–229.
27
28
29
30 (42) Noubigh, A.; Akermi, A. Solubility and Thermodynamic Behavior of Syringic Acid in
31 Eight Pure and Water + Methanol Mixed Solvents. *J. Chem. Eng. Data* **2017**, *62* (10),
32 3274–3283.
33
34
35
36 (43) Noubigh, A.; Jeribi, C.; Mgaidi, A.; Abderrabba, M. Solubility of Gallic Acid in
37 Liquid Mixtures of (Ethanol+water) from (293.15 to 318.15)K. *J. Chem. Thermodyn.*
38 **2012**, *55*, 75–78.
39
40
41
42 (44) Dali, I.; Aydi, A.; Alberto, C. C.; Wüst, Z. A.; Manef, A. Correlation and Semi-
43 Empirical Modeling of Solubility of Gallic Acid in Different Pure Solvents and in
44 Binary Solvent Mixtures of Propan-1-Ol + Water, Propan-2-Ol + Water and
45 Acetonitrile + Water from (293.2 to 318.2) K. *J. Mol. Liq.* **2016**, *222*, 503–519.
46
47
48
49 (45) Abbott, S.; Booth, J. J.; Shimizu, S. Practical Molecular Thermodynamics for Greener
50 Solution Chemistry. *Green Chem.* **2017**, *19* (1), 68–75.
51
52
53 (46) Dhapte, V.; Mehta, P. Advances in Hydrotropic Solutions: An Updated Review. *St.*
54 *Petersbg. Polytech. Univ. J. Phys. Math.* **2015**, *1* (4), 424–435.
55
56
57
58 (47) McKee, R. H. Use of Hydrotropic Solutions in Industry. *Ind. Eng. Chem.* **1946**, *38* (4),
59 382–384.
60

1
2
3
4
5
6
7
8
9
10
11
12
13
14
15
16
17
18
19
20
21
22
23
24
25
26
27
28
29
30
31
32
33
34
35
36
37
38
39
40
41
42
43
44
45
46
47
48
49
50
51
52
53
54
55
56
57
58
59
60

- (48) Gaikar, V. G.; Sharma, M. M. Separations with Hydrotropes. *Sep. Technol.* **1993**, *3* (1), 2–11.

Table of Contents



For Table of Contents Use Only

Synopsis: Glycerol ethers are shown in this work to be excellent hydrotropes for the solubility enhancement of gallic and syringic acids in water.